Work Order ID 59662 Wednesday, June 09, 2010 11:39:59 AM				
Item ID: Revision ID:	D4008-7	Accept		
Item Name:	Washer			

Cust Item ID: Customer:

Reference: Run Start Date: 106-09 Tooling: **Process Plan: Approvals:** Date: Stop QC:_ Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject Insp.

Work Center ID Description **Run Hours** Code Qty Qty Stamp Number Draw Nbr **Revision Nbr** D4008 Α 100 0.00

Memo

Start Qty: 20.00

Req'd Qty: 20.00

0.00

Hardinge CNC Lathe Small

TURN AS PER DWG AND FOLIO FA909

DWG REV:___

DWG REV: A-FOLIO REV: WITH

DEBURR

S/ 10/06/16

QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

5/ 10/06/16

20 \$

Setup Start



Page 1

Stop

Start Date:

Required Date: 6/17/2010

6/9/2010

Hardinge

110

Quality Control

Dart	Aer	osp	ace	Ltd
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W/O:		WORK ORDER CHANGES								*
DATE	STEP	STEP PROCEDURE CHANGE				Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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				!						
Part No	:	PAR #:	Fault Cate	gory:	NC	R: Yes	No DQ	A:	Date:	
	Resolution: Disposition:									
NCR:			WORK ORD	ER NON-CONFO	DRMANCE	(NCR)			
DATE	STEP	Description of NC			Section B				Approval	Approval
,		Section A	Initial Chief Eng	Action Descri Chief Eng		Sign & Date	Secti	cation on C	Chief Eng	QC Inspector
				÷						
					;					
				:						

Work Order ID 59662

Page 2

Item ID:

D4008-7

Accept

Setup Start

Stop



Revision ID:

Item Name:

Required Date: 6/17/2010

Washer

Wednesday, June 09, 2010 11:39:59 AM

6/9/2010

Start Qty: 20.00 Req'd Qty: 20.00

Cust Item ID:

Customer:

Reference:

Start Date:

Process Plan:

Date:

Tooling:

Date:

Start



Approvals:

Date: _____

SPC (Y/N):

Date:

Stop

Run

Sequence ID/

Work Center ID

120

QC

Quality Control

Operation **Description**

OC:

QC8- Inspect parts - second check

Set Up/ **Run Hours**

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Reject Number

Insp. Stamp

Memo

0,00 and 10/06/16

20 0

130

Packaging

Packaging

Identify as per dwg & Stock Location!

Memo

0.00

0.00

10-6-17 56

140

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/06/21787 MF 10-6-18

Dart Aeros	pace Ltd
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W/O:			W	ORK ORDER CHANGES	<u> </u>				9
DATE	STEP	PROCEDURE CHANGE				Date	Qty	Approval Chief Eng /	Approval
								Prod Mgr	QC Inspector
									
								:	
Part No	:	PAR #:	Fault Cat	egory:	NCR: Yes	No DQA	۸:	Date:	
	Re	solution:	Dispositi	on: (A: N/C Closed: Date:				
NCR:			WORK OR	DER NON-CONFORMAN	CE (NCF	R)			
DATE	OTED	Description of NC	escription of NC Corrective Action		Section B		Verification		Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Section		Approval Chief Eng	QC Inspector
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				;					
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Picklist Print

Wednesday, June 09, 2010 11:40:04 AM

Work Order ID: 59662

Parent Item:

Comments:

D4008-7

Parent Item Name:

Washer

IPP REV:A NEW ISSUE 10-02-02 JLM VERIFIED BY:EC 10.05.03 as per ECN10-562 DD verified by:EC

IPP Rev:B

Start Date: 6/9/2010

Required Date: 6/17/2010

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name

Replacement Mfg/ Purch Item ID

Purchased

Primary Bin Item Location No

Last Location Route Seq ID 100

Unit of Measure Hand f

Qty on 27.7900

Qty per Kit Total 0.028

Otv 0.589474

Date Issued Issued

Qty

Status

Page 1

MDELRINR1.000

Delrin Round Bar 1"

Location	Loc Qty	Loc Code

MAT 22.5 114733 22.5 MAT050 5.29

108804 5.29 -53 AL 5/ 10/06/16

Dart Aerospace	Ltd
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W/O:			V	VORK ORDER C	HANGES					<u>_</u>
DATE	STEP	PRO	OCEDURE CH		ī	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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	R	esolution:	Disposit	ion:	QA	QA: N/C Closed: Date:				
NCR:	·	1	WORK OR	DER NON-CONF	ORMANCE	(NCR)			*****
DATE	STEP			Corrective Action	Var			cation	Approval	Approval
		Section A	Initial Chief Eng	Action Descr Chief Eng	ription	Sign & Date	Secti	on C	Chief Eng	QC Inspector
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ART AEROSPACE LTD	Work Order:	19662
ART ALROOF ACE 1.5		\
	Part Number:	1-8004
escription: Washel		
A LINE ABOVE A		Page 1 of 1
spection Dwg: 124008-7Rev: /		

		<u></u>				
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
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Measured by:	17	Audited by:	and	Prototype Approval:	N/A
	0/06/16	Date:	10/06/16	Date:	N/A

Rev	Date	Lozanne	Revised by	Approved
A		New Issue	KJ/JLM	

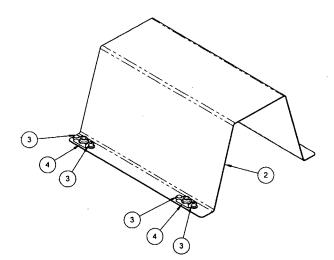
5 3 2 QTY. ITEM NO. PART NUMBER JOHN CAMERON AVIATION PART NUMBER DESCRIPTION 1 х D4008-041 AUX TANK FILLER SPLASH GUARD ASSEMBLY JCA-M47-2-26 2 2 D3941-1 RUBBER CUSHION 3 1 D4008-1 FUEL FILLER SPLASH GUARD CHANNEL 4 1 D4008-5 HINGE 5 2 D4008-7 WASHER 6 1 D4008-9 SPRING 7 5 MS20470AD3-3 RIVET 8 2 MS35206S245 SCREW 9 6 NAS1149DN832J WASHER 10 2 MS21042L08 NUT [10] **SECTION A-A** SCALE: 2X TYP SHOP COLA RETURN TO ENGINEERING. UNCONTROLLED CO PY SUBJECT TO AMENTAGE WITHOUT NOTICE 10> (2) D4008-041 AUX TANK FILLER SPLASH GUARD ASSEMBLY NEW ISSUE Α 10.02.05 REV. DESCRIPTION DATE 1) MATERIAL: NIA
2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005.4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005.TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4008-041" AND B/N USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.15 lbs DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. A D4008 MFG. APPR SHEET 1 OF 10 APPROVED TITLE SCALE 7) WEIGHT, 25 IS 8) ATTACH D3941-1 RUBBER CUSHION USING SILICONE ADHESIVE, TRIM TO FIT, AFTER POWDER COAT 9) MASK HINGE PIN AREA BEFORE POWDER COAT 10) INSTALL D4008-7 WASHER AND D4008-9 SPRING AFTER POWDER COAT SPLASH GUARD DE APPR. NTS COPYRIGHT @ 2010 BY DART AEROSPACE LTD
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W/O:		WORK ORDER CHANGES										
DATE	STEP	PRO	OCEDURE CH	IANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
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						NCR: Yes No DQA: Date:						
	Res	solution:	Disposition: QA: N/C Closed: Date					Date:				
NCR:		•	WORK OR	DER NON-CONFORM	ANCE (NCR)						
DATE	STEP	Description of NC			ion B	Verific	ation	Approval	Approval			
		Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C		Chief Eng	QC Inspector			
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	1 1											

		5	. 4
QTY. -043	PART NUMBER	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER
Х	D4008-043	FUEL PUMP SPLASH GUARD ASSEMBLY	JCA-M47-2-29
1	D4008-3	FUEL PUMP SPLASH GUARD COVER	
8	MS20426AD3-3	RIVET	
4	MS21059L08	NUT PLATE	
		043 PART NUMBER X D4008-043 1 D4008-3 8 MS20426AD3-3	DESCRIPTION DESCRIPTION



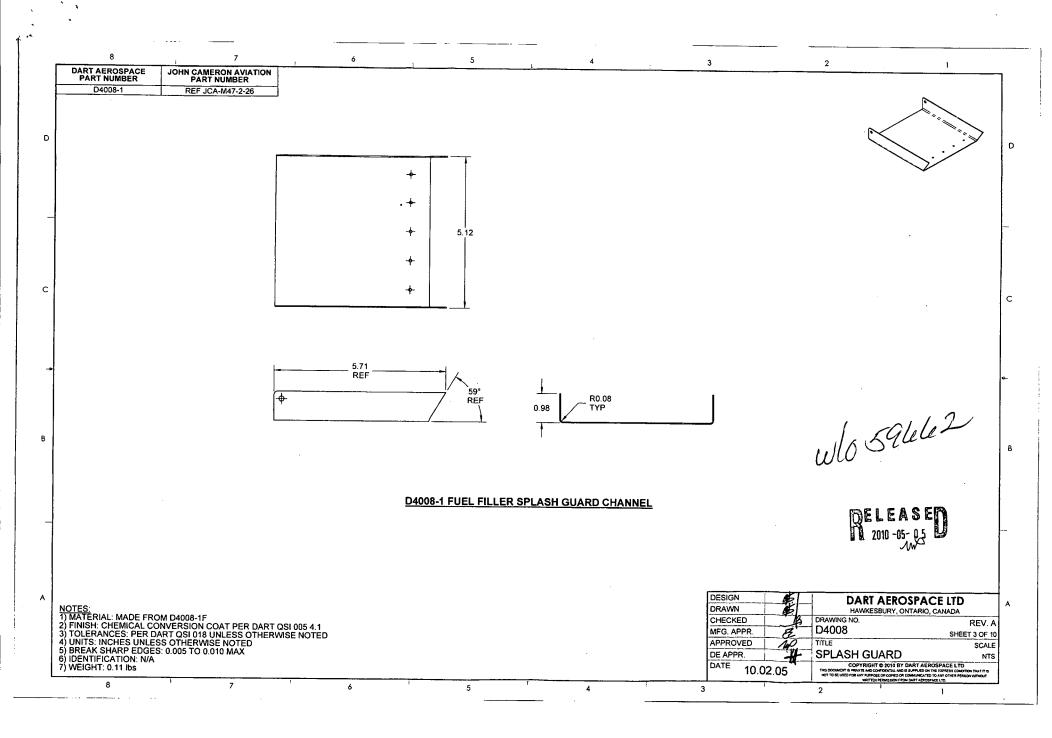
D4008-043 FUEL PUMP SPLASH GUARD ASSEMBLY

wlo 59ld 2

NOTES:
1) MATÉRIAL:
2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.05 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4008-043" AND B/N USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.46 lbs

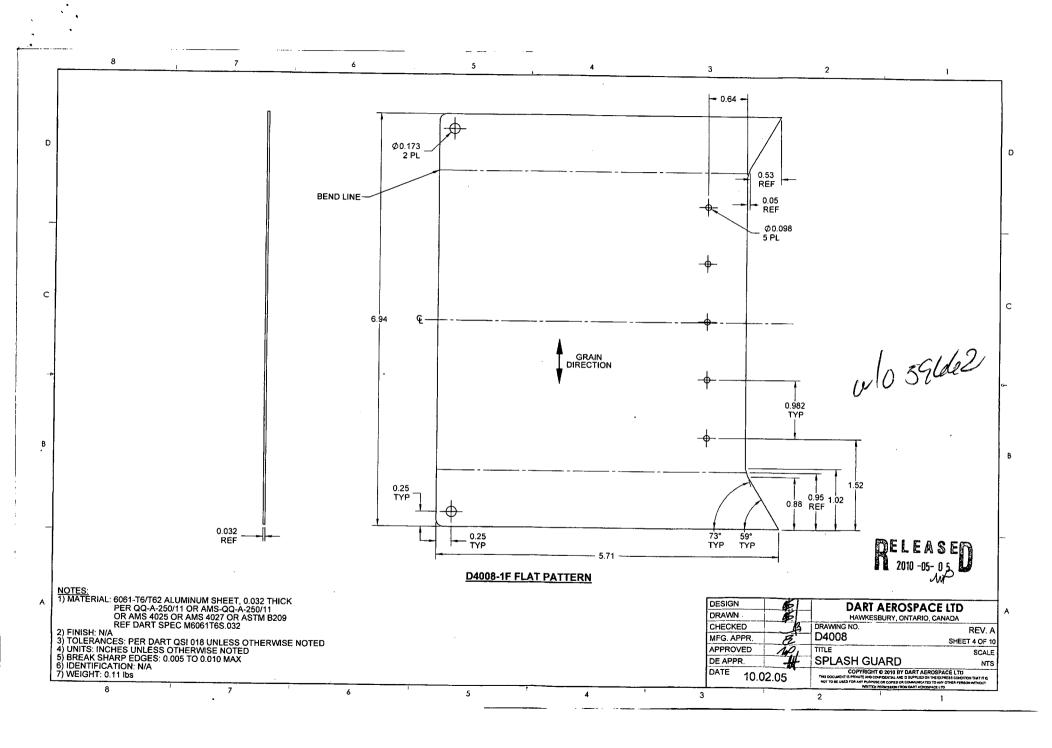
DESIGN	AS!	DART AEROSPACE LTD				
DRAWN	6 5	HAWKESBURY, ONTARIO				
CHECKED	B	DRAWING NO.	REV A			
MFG. APPR.	B	D4008	SHEET 2 OF 10			
APPROVED	140,11	TITLE	SCALE			
DE APPR.	-14	SPLASH GUARD	NTS			
DATE 10.0	2.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PROVITE AND COMPOSITION, AND IS UMPLIED ON THE EMPRISE CONDITION THAT IT IS NOT TO BE USED FOR ANY PROPOSE OR COMPOSITION TO HAVE PERSON WITHOUT				

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W/O:		WORK ORDER CHANGES										
DATE	STEP	PRO	OCEDURE CH	IANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
Part No:		PAR #:	Fault Ca	tegory:	ICR: Yes No DQA: Date:							
	Re	esolution:	Disposit	ion:	QA:	N/C CI	osed:		Date: _			
NCR:		\	WORK ORI	DER NON-CONFORM	ANCE	(NCR)			•		
DATE	STEP	Description of NC			Corrective Action Section B			ation	Approval	Approval		
	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section		Chief Eng	QC Inspector		
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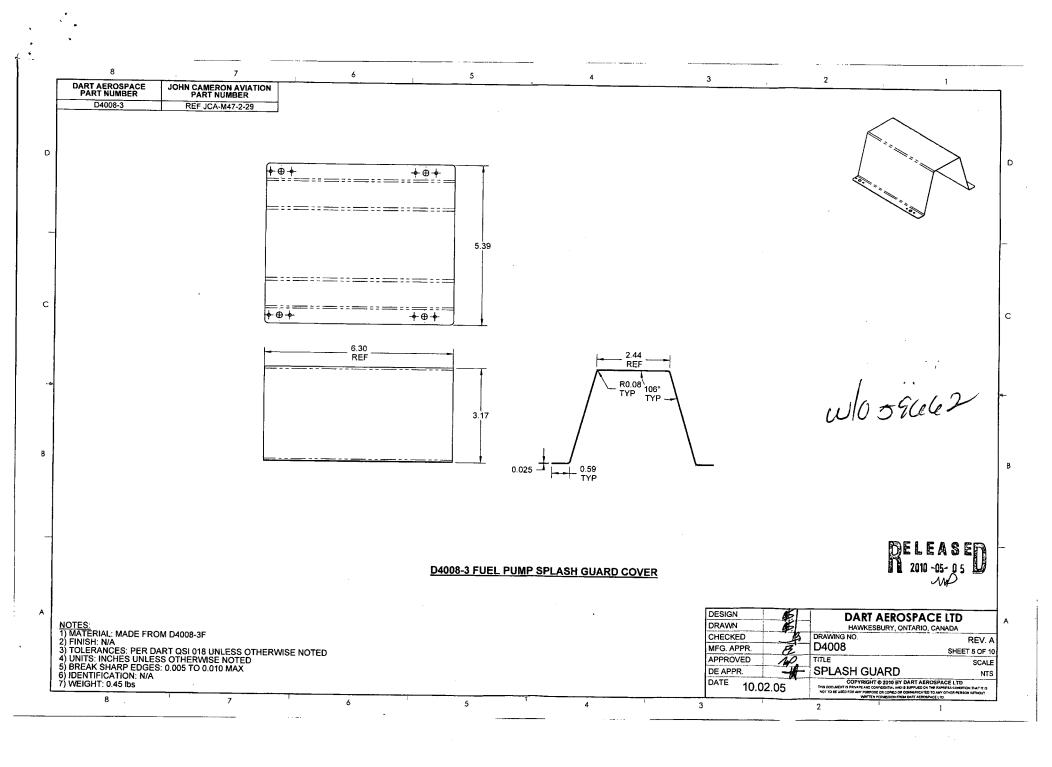
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DATE	STEP	Description of NC	Corrective Action Section Initial Action Description			Cian e Ve			Approval	Approval		
	Section A		Initial Action Desc Chief Eng Chief En		Date		Section C		Chief Eng	QC Inspector		
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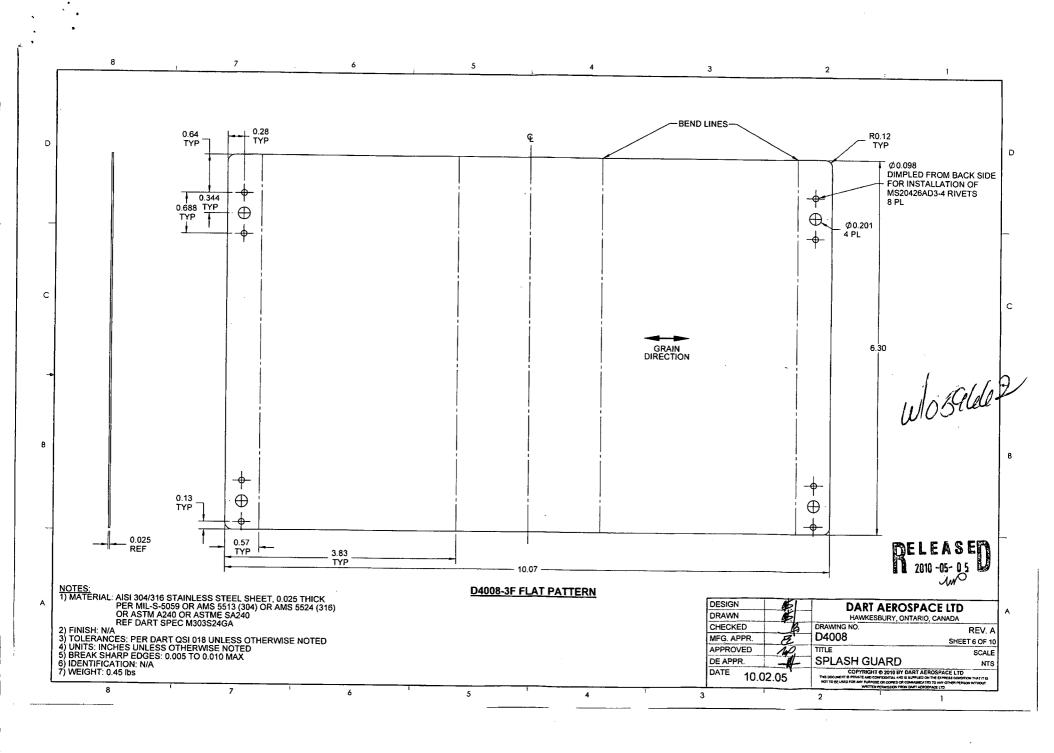
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	Resolution:						Date: _						
NCR:			WORK ORD	ER NON-CONFORM	ANCE (NCR)							
DATE	STEP	Description of NC	12	Corrective Action Section B			ion Approval	Approval					
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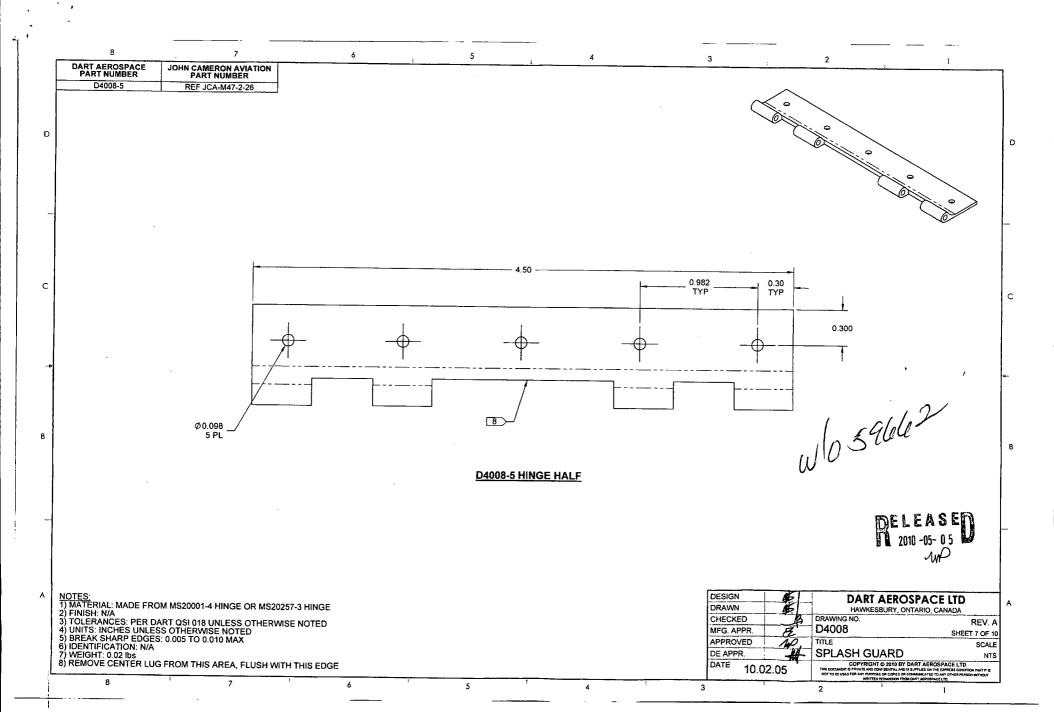


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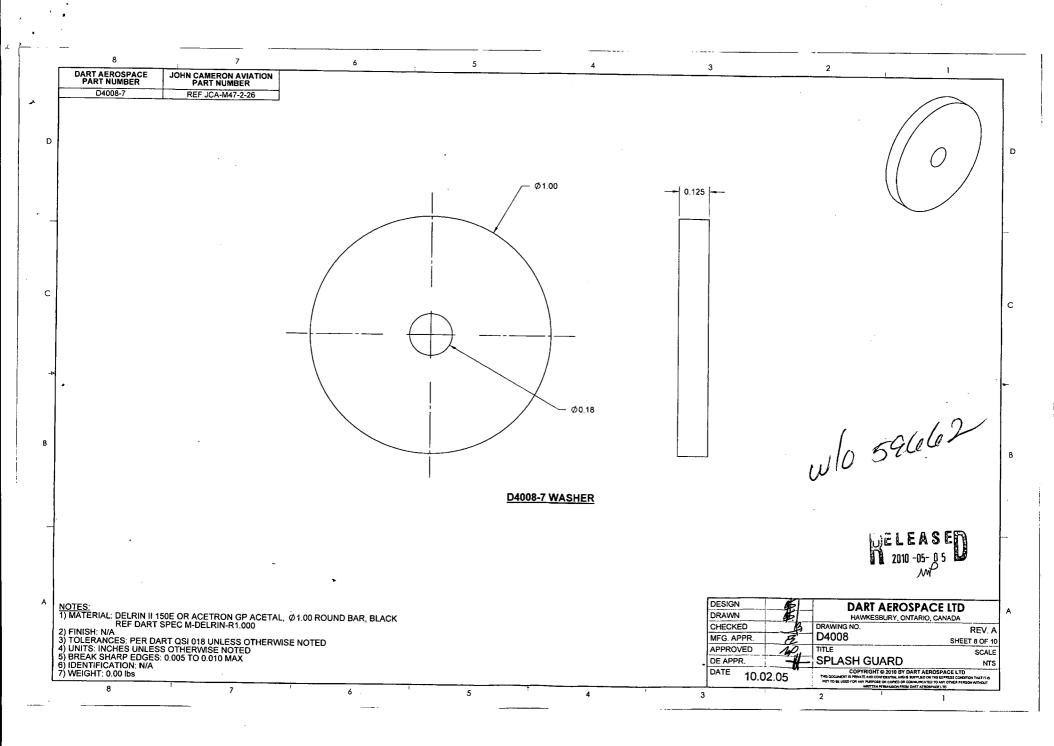
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DATE	STEP	PRO	PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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Part No		PAR #:	Fault Cate	egory:	NCF	R: Yes	No DQ	Δ:	Date:			
			Disposition:									
NCR:			WORK ORE	ER NON-CONFORM	ANCE	(NCR)					
DATE	STEP	Description of NC Section A	Corrective Action Initial Action Descrip				Verification Section C		Approval Chief Eng	Approval QC Inspector		
			Chief Eng	Chief Eng		Date				100		
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W/O:		WORK ORDER CHANGES									
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		PAR #:	Fault Cate	gory:	NCR: Yes No DQA: Date:						
	Res	solution:	Disposition	າ:	_ QA: N/C C	losed:		Date: _			
NCR:		•	WORK ORDI	ER NON-CONFORM	ANCE (NC	₹)					
DATE	STEP	Description of NC		Corrective Action Section B Initial Action Description			cation	Approval	Approval		
	Section A	Section A	Chief Eng	Action Description Chief Eng	Sign & Date		on C	Chief Eng	QC Inspector		
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Part No	:	PAR #:	Fault Cate	egory:		NCR: Yes	No DQ	A:	Date:				
			Disposition:										
NCR:		\	WORK ORD	ER NON-CON	FORMAN	CE (NCF	R)						
DATE	STEP	Description of NC Section A	Initial	Corrective Action Action Des		B Sign 8	Verific Section		Approval Chief Eng	Approval QC Inspector			
			Chief Eng	Chief E		Date	Section	311 C	Office Eng	QC Inspector			
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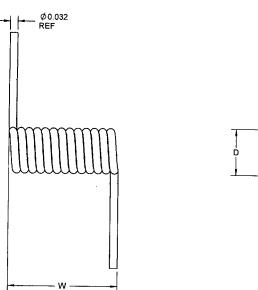


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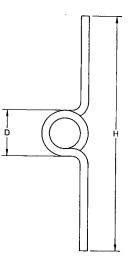
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		esolution:						
NCR:	7	V	VORK ORI	DER NON-CONFORMA	NCE (NCR)			
DATE	STEP	Description of NC Section A	Initial	Corrective Action Section Action Description	on B Sign &	Verification		Approval
		Section A	Chief Eng	Chief Eng	Date	Section C	Chief Eng	QC Inspector
								!
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DART AEROSPACE PART NUMBER JOHN CAMERON AVIATION PART NUMBER D4008-9 REF JCA-M47-2-26

SPECIFICATION CONTROL DRAWING



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DART P/N	SUPPLIER	SUPPLIER P/N	WIDTH "W"	HEIGHT "H"	DIAMETER "D"	MATERIAL
D4008-9	VICTORY SPRING	N/A	0.46	0.99	0.19	STAINLESS STEEL SPRING WIRE
D4008-9	BELL HELICOPTER	206-031-140-001	0.46	0.99	0.19	STAINLESS STEEL SPRING WIRE

D4008-X SPRING

DELEASED 2010 -05- 05

D

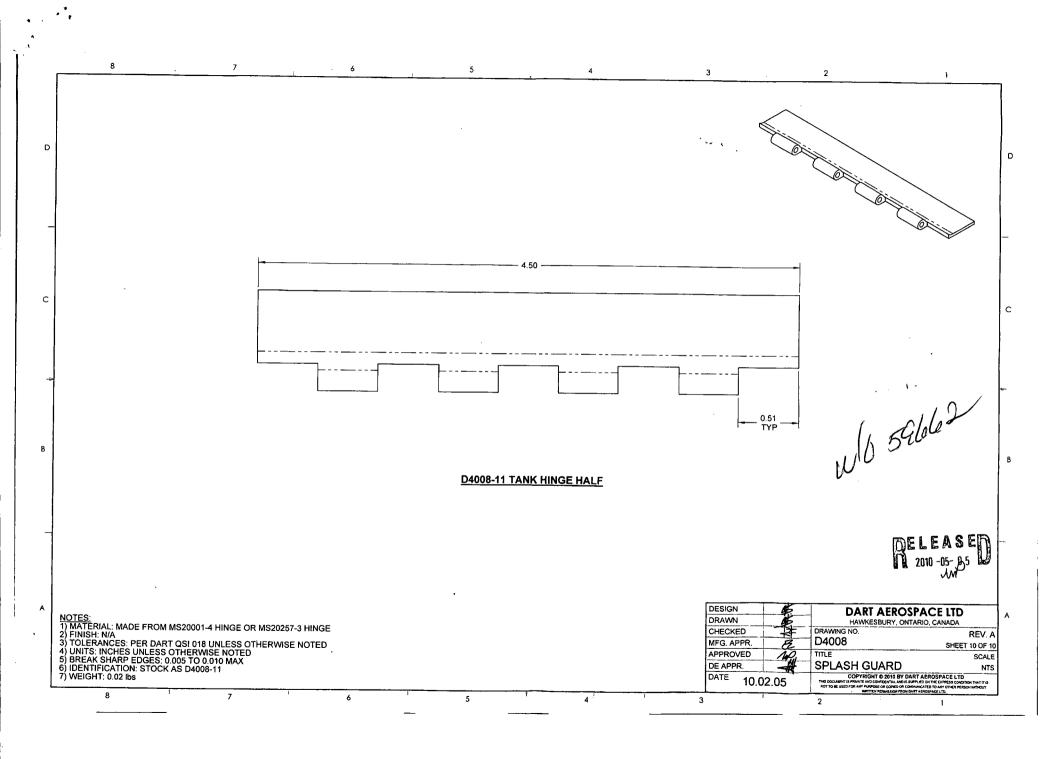
NOTES:
1) MATERIAL: T301 OR 304 STAINLESS STEEL SPRING WIRE Ø0.032 PER ASTM A313
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.00 lbs

DESIGN	ASI	DART AEROSPA	CELTD
DRAWN	1	HAWKESBURY, ONTARK	
CHECKED	B	DRAWING NO.	REV. A
MFG. APPR.	E	D4008	SHEET 9 OF 10
APPROVED	140.	TITLE	SCALE
DE APPR.	-#	SPLASH GUARD	NTS
DATE 10.0	2.05	COPYRIGHT © 2010 BY DART AI	ON THE EXPRESS CONDITION THAT IT IS

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Dart Aerospace	Ltd
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W/O:			W	ORK ORDER CHANG	GES					<u></u>	
DATE	STEP	PRO	OCEDURE CHA	ANGE	E	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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Dart Aerosp	ace Ltd
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W/O:			WORK ORDER (CHANGES				
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